

Date: Monday, 18/08/2008 3:44:54 PM  
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FWD ADJUSTABLE BLADE SUPPORT ASSY  
Job Number : 41367  
Estimate Number : 13433  
P.O. Number :  
This Issue : 18/08/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : / / Type : LARGE FAB ASSY  
Previous Run : 40608  
Written By :  
Checked & Approved By : JUL 08.8.19  
Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Part Number : PB674300115  
Drawing Number : B6743001 P.7  
Project Number : N/A  
Drawing Revision : B1  
Material :  
Due Date : 18/09/2008 Qty: 8 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PB6743001257 Inner Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Inner Tube  
batch: 341495

18.08.26 2

2.0 PB6743001249 Inner Tube Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Inner Tube Bushing  
batch: 16147

18.08.26 2

3.0 PB6743001253 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Gusset  
batch: 41117

18.08.26 2

4.0 PB6743001254 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Gusset  
batch: 40053

18.08.26 2

5.0 PB674300171 PB67-43001-71



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
PB67-43001-71  
batch: 41512

18.08.26 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date:  
User:

Monday, 18/08/2008 3:44:54 PM  
Julie Lecocq

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Job Number: 41367

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

*Handwritten:* 08.09.29 2

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*Handwritten:* Rpl 08.09.29

*Handwritten:* BF 08-09-29

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* S 08/02/29 @2

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

HELICAL INSERT

*Handwritten:* BM17935

*Handwritten:* 08.09.29

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- install helicol insert as per dwg

*Handwritten:* 08.09.29 2

*Handwritten:* 08.09.29 2

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* S 08/02/29 @2

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Handwritten:* 1/4 08/09/30

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*Handwritten:* M 102316

*Handwritten:* (2X)

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

*Handwritten:* m-l 08/09/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 41367

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00  
320 OF  
9:30

M-1

(2X)  
08/09/30

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



98



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-30 (42)

15.0

PB674300173

20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

20 Degree Cover Plate

batch: 41513

MF 08-10-22

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

PB67-43001-83

batch: B41516

MF 08-10-22

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

Screw

batch: M109031

MF 08-10-22

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

WASHER

batch: M109031

MF 08-10-22

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

F2 / Cpl

08/10/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

500/10/23 (42)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

core

welding

500/10/23 (42)

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/23 (42)

Job Completion



MF 08-10-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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